

AWC -022



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

POSITIVE RECALL

EFFECTIVE 19/07/14 AUTH SAN
RELEASED A/D DATE AUG 2, 2014

DAS
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9-89

6F9540V00231

Job Sheet R198312



Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Job Created: 7/24/19

Due Date: 8/9/19

Type: Rework

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

U/R

Priority: Medium

SAN
19/07/24

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		8/9/19	0.00 0.00	Packaging 1 - 1		
						Packaging 1 - 2		
						Packaging 1 - 3		
						Packaging 1 - 4		
						Packaging 1 - 5		
						Packaging 1 - 6		
						Packaging 1 - 7		
						Packaging 1 - 8		
						Packaging 1 - 9		
						Packaging 1 - 10		
						Packaging 1 - 11		
						Packaging 1 - 12		
						Packaging 1 - 13		
						Packaging 1 - 14		
						Packaging 1 - 15		
						Packaging 1 - 16		
						Packaging 1 - 17		
						Packaging 1 - 18		
						Packaging 1 - 19		
						Packaging 1 - 20		
						Packaging 1 - 21		
						Packaging 1 - 22		
						Packaging 1 - 23		
						Packaging 1 - 24		
						Packaging 1 - 25		
						Packaging 1 - 26		
						Packaging 1 - 27		
						Packaging 1 - 28		
						Packaging 1 - 29		
						Packaging 1 - 30		
						Packaging 1 - 31		

AS 19-7-25



Container No: S200549



6F9540V00231

No: R198312

No/Batch: S200549

g: D

r:

19:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/25/19

Plex 7/24/19 3:15 PM dart.lacelle.linda

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
115 Small Fab - 2 - B4B	1 pcs	8/9/19	0.00 1.00		Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	AR 19-7-25
					Small Fab - 7 - B4B	
					Conventional Mill - 1 - B4B	DAS 52 19/07/26
					Conventional Mill - 2 - B4B	9-89
120 Conventional Mill - 1 - B4B	1 pcs	8/9/19	0.25 0.33		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS 68 JUL 26 2019
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125 QC 5	1 pcs	8/9/19	0.00 0.00		ATG 001	KH 2019-07-29
					Packaging 2 - 1 - B4B	
130 Outsource - 4 - Anodize	1 pcs	8/9/19	0.00 0.00		Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP JUL 30 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
135 Packaging 2-1 - Receive - B4B	1 pcs	8/9/19	0.00 0.00			

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
140 QC 6	1 pcs	8/9/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	JUL 30 2019
					QC 6 - 81	
145 Small Fab - 3 - B4B	1 pcs	8/9/19	0.00 0.50		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	AUG 19 - 7 - 30
					Small Fab - 7 - B4B	
150 QC 5	1 pcs	8/9/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	AUG 01 2019
					QC 5 - 61	
					QC 5 - 81	
170 QC 4	1 pcs	8/9/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	DAS 75 9-89
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	AUG 02 2019
					QC 4 - 75	
180 Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
						DAS 75 9-89
						AUG 02 2019

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JUL 30 2019

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AUG 01 2019

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AUG 02 2019

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AUG 07 2019



Sec
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for Concession,

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AUG 2nd, 2019

			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
190 DC - 1 - B4B	1	8/9/19	0.00 0.00	DC - 1 - B4B
	pcs			DC - 2 - B4B
200 QC 21 - FG	1	8/9/19	0.00 0.00	QC 21 - FG - 21
	pcs			QC 21 - FG - 70
				QC 21 - FG - 53

Part Op 110 - PULL FROM STOCK

Descriptions: **115** - REMOVE D4842-041 OUT FROM KIT, DISASSEMBLE AND KEEP HARDWARE TO REASSEMBLE.
120 - FACE DOWN (0.005") EACH D4842 AS PER DWG AND DEBURR.
125 - QC5- Inspect part completeness to step on W/O
130 - Issue P/O : 44131 AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED
145 - REASSEMBLE USING ORIGINAL HARDWARE AS PER DWG Assemble as per dwg and apply loctite 598 on all faying surfaces.
170 - (QC4- 100% Inspect kits for completeness)
180 - Identify and pack for shipping as per PPP 6F9540V00231
190 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6F9540V00231 MS21042608 MS 3703T-08-19	AW169 Lower Cutter Installation Assembly	1 pcs (1 ea) 6 6	110-Packaging 1 - Pick Kit	5195550 3193129 5006968

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	6F9540V00231	1	4	0

Part Specifications

Specifications could not be found.

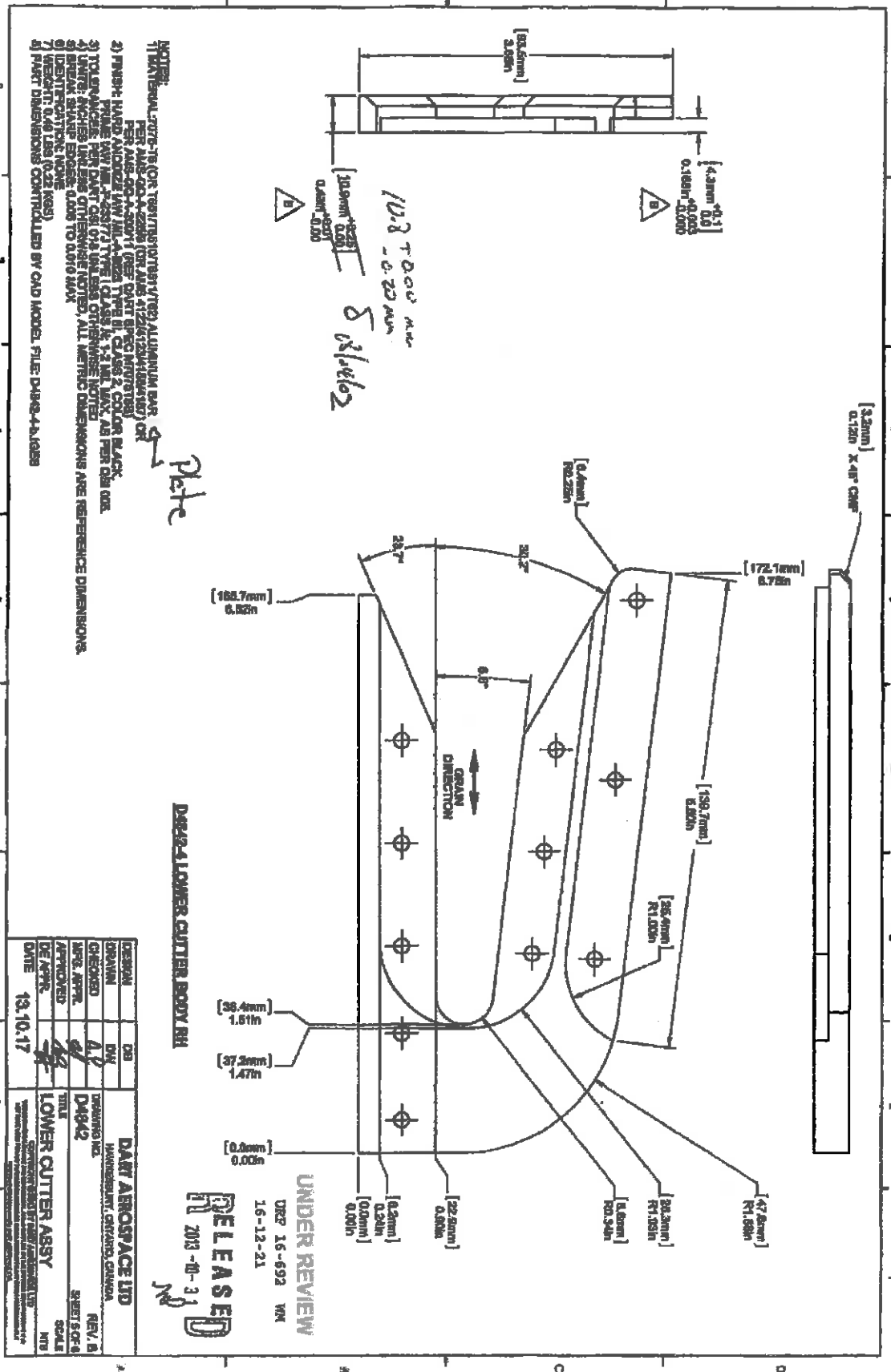


Dart Hawkesbury
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Fax 613 632-5246

Inventory

Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date	Invent Typ
Part Number: 6F9540V00231 Revision: AW169 Lower Cutter Installation Assembly																	
200	QC 21 - FG	S171709	192034		1 pcs	0	S171709	GA026		Stock	4/11/2019	*	DATE				False
		S195550	192031		1 pcs	0	S195550	Concession Bin		Stock	7/3/2019	*	DATE		CHG002		False
		S195594	192032		1 pcs	0	S195594	Concession Bin	Concession	7/3/2019	*	DATE		CHG002		False	
		S195595	192030		1 pcs	0	S195595	Concession Bin	Concession	7/3/2019	*	DATE		CHG002		False	
Operation Totals:		4			4	0											
Part Totals:		4			4	0											
Totals:		4			4	0											

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1) MATERIAL: 7075-T6 (OR 7050-T6) ALUMINUM BAR
 2) FINISH: HAND ANODIZED (OR MIL-ANODIZE TYPE II, COAT 2, COLOR BLACK)
 3) TOLERANCES: DIM PARTS: 0.000 INCHES (0.000 INCHES) UNLESS OTHERWISE NOTED. ALL DIMENSIONS ARE REFERENCE DIMENSIONS.
 4) UNITS: DIMENSIONS ARE IN INCHES (DIMENSIONS IN MILLIMETERS)
 5) BREAK: SHARP BREAKS: 0.000 TO 0.010 INCH
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.46 LBS (0.22 KGS)
 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-4-1-1028

DESIGN	REV	DATE	BY	APP	DESCRIPTION
DESIGN	01	13.10.17	DAI	DAI	DAI AEROSPACE LTD
CHECKED	01		DAI	DAI	DAI AEROSPACE LTD
APPROVED	01		DAI	DAI	DAI AEROSPACE LTD
DATE	13.10.17				DAI AEROSPACE LTD

D4842 LOWER CUTTER BODY RH

RELEASED
2013-10-31

UNDER REVIEW
 D4842-4-1-1028
 16-12-21



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: <u>R198312</u>		DISPOSITION		DEPARTMENT/PROCESS																																															
Part No. <u>CF9540V00231</u>		Rework Scrap Use-as-is		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging																																															
Date: _____		Sequence #: _____		QTY Affected: _____																																															
Description Work Order Deviation		Disposition																																																	
Remove 0.005 of Material from base face for the following Parts D4842-3 and 4842-4 (see attached Drawing) Measurement SA 0.425 0.000 + 0.002 - also at assembly use bolt 3x end washer 3x at base of cable cutter tighten snug for the time being when Sealant dries up, the remove bolts and washers		re-work D4842-041, D4842-31-24 as per attached instructions/drawing																																																	
Root Cause		FAULT CATEGORY																																																	
<table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		<table border="1"><tr><td>Contamination</td><td></td><td>Power Loss/Surge</td><td></td></tr><tr><td>Misaligned/off center</td><td></td><td>Folio/Program</td><td></td></tr><tr><td>BOM/Route</td><td></td><td>Grain Direction</td><td></td></tr><tr><td>Broken/Damage/Defect</td><td></td><td>Weld</td><td></td></tr><tr><td>Incomplete/Unclear Instructions</td><td></td><td>Wrong Stock Pulled</td><td></td></tr><tr><td>Drill Holes</td><td></td><td>Out of Sequence</td><td></td></tr><tr><td>Fit/Function</td><td></td><td>Off-set/Set-up</td><td></td></tr></table>						Contamination		Power Loss/Surge		Misaligned/off center		Folio/Program		BOM/Route		Grain Direction		Broken/Damage/Defect		Weld		Incomplete/Unclear Instructions		Wrong Stock Pulled		Drill Holes		Out of Sequence		Fit/Function		Off-set/Set-up	
Operator																																																			
Manufacturing Process																																																			
Equip/Tooling																																																			
Handling/Preservation																																																			
Material																																																			
Product Improvement																																																			
Process Improvement																																																			
Human Factors																																																			
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Broken/Damage/Defect		Weld																																																	
Incomplete/Unclear Instructions		Wrong Stock Pulled																																																	
Drill Holes		Out of Sequence																																																	
Fit/Function		Off-set/Set-up																																																	
Other/Details:		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread																																																	

Completed By	Lead hand / Supervisor	QC / QA Coordinator
S.L. 19/07/25	and 19/07/26	DAS 68 9-89

MBB (OSIN21)
DAS 51 9-89 19/07/25



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044131



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044131

PO Date: 7/29/19

Due Date: 7/31/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ****RUSH****

E-MAILED
2019-07-30

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R198348	D4842-3	Lower Cutter Body, LH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed X8	-	7/31/19	8 pcs	0 pcs	8 pcs	\$22.50/pcs	\$180.00
2	R198349	D4842-4	Lower Cutter Body, RH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed X4	-	7/31/19	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00



Dart Aerospace Ltd.
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Hawkesbury, ON
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PURCHASE ORDER

POHB044131



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	R198314	6F9540V00231	AW169 Lower Cutter Installation Assembly Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
	R198313	S200453		Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
	R198312	S200549		Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
Sub Total:							3	0	3		\$67.50
4	R198330	D4842-041	Lower Cutter Assembly Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005. C OF C IS REQUIRED	Firmed	-	7/31/19	1 pcs	0 pcs	1 pcs	\$22.50/pcs	\$22.50
Grand Total:											\$360.00

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044131



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 10:28 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
8 ea	Part: D4842-3 Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25663 PO: POHB044131		Rev: B Line: 1
4 ea	Part: D4842-4 Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25664 PO: POHB044131		Rev: B Line: 2
3 ea	Part: 6F9540V00231 AW169 Lower Cutter Instal Ass Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 25665 PO: POHB044131		Rev: Line: 3
1 ea	Part: D4842-041 Lower Cutter Assembly Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: B
Made in Canada.			

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918320

Date: 30-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0001-.0002" (1 - 2 mils) per drawing. Job: 25666 PO: POHB044131 Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 30 2019</u> Certified Signature: <u>/</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

RECEIVED
JUL-30 2019
DART AEROSPACE LTD.